

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 74.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017291**Date Inspected:** 30-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 815**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Goodwin Steel, UK**Location:** Trentham, UK

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>
<b>Inspected CWI report:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
		<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Bridge No:</b>	34-0006	<b>Component:</b>	Cable Band	

**Summary of Items Observed:**

The following report is based on METS observations at Goodwin International, Trentham, UK on this date:

The QA Inspector observed welding of Casting GG29423-7, Drawing Number 5540-B4-1-F. The welding was being performed by Mr. Dan McDonagh . Mr. McDonagh was using WPS 271 Revision 1. The welding was being performed at 16.7 volts and 165 amps. The heat input was and the travel speed were being monitored. The filler metal was AWS A5.28 ER70S-A1. The shielding gas was Argon with a flow rate of 12 L/min These are within the allowable range of the WPS. Welding was being performed in the 2G position.

**SHOP REVIEW:**

The QA Inspector periodically observed the in process machining of an assembled B10 Type 2 cable band, castings GG29440-4, 5540-B10-2-M and GG29441-2, 5540-B10-2-F for East Panel Point 36. The interior bore was being machined to finished condition on the TSS-30 vertical mill. Goodwin International personnel performed the machining.

The QA Inspector periodically observed the in process machining of an assembled B10 Type 2 cable band, castings GG29440-3, 5540-B10-2-M and GG29441-4, 5540-B10-2-F for West Panel Point 38. The interior bore was being rough machined on the Webster and Bennet vertical mill Goodwin International personnel performed the machining.

The QA representative observed the casting GG29442-M-1, 5540-B1-2-M at machining center BTF-2. The joint

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## WELDING INSPECTION REPORT

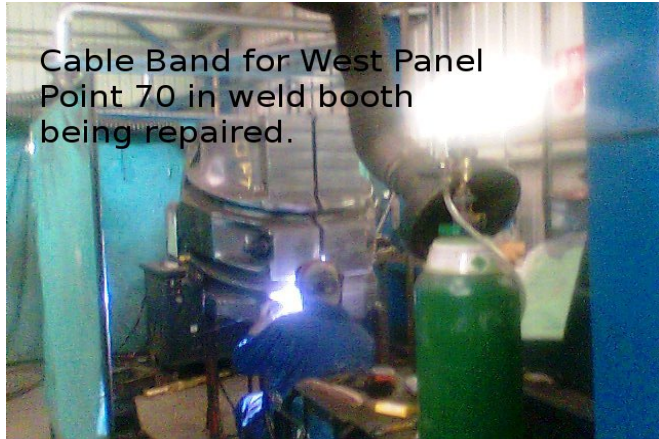
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faces are being machined to final finish requirements by Goodwin International personnel.

The QA inspector periodically observed that Goodwin International personnel perform finish grinding of assembled B9 cable band, castings GG29436-3, B9-1-M and GG29437-5, B9-1-F for panel point 26 East bound.

All sharp edges from the machining operations and suspender groove transitions were ground to required finish by Goodwin International personnel.



Cable Band for West Panel  
Point 70 in weld booth  
being repaired.

### Summary of Conversations:

No relevant conversations

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Riegler,Randy	Quality Assurance Inspector
<b>Reviewed By:</b>	Edmondson,Fred	QA Reviewer

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